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ABSTRACT OF THE DISCLOSURE

5 A ball nut has at least one internal bearing race with a first end and second end, and at least one recirculating crossover passage for connecting the first end with the second end of the bearing race to form a continuous recirculating path for a plurality of ball bearings. A method for producing a ball nut includes the steps of forming at least a portion of the ball nut body with a helix passage for receiving a plurality of ball bearings, forming a crossover passage in communication with the helix passage for returning the plurality of ball bearings to an opposite end of the helix passage, and assembling the ball nut body portions to position the helix passage and operable orientation with respect to the crossover passage to define at least one raceway having a single recirculating rotational path for receiving the plurality of ball bearings. The ball nut body can be formed by being drawn, coined, metal injection molded, roll formed, through rolled, stamped and/or overmolded. The crossover passage can be formed integrally with the ball nut body, or can be formed as an insert or plug formed of a plastic material or metal injection molded, or can be performed during an over mold operation.

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